

# Work Order ID 60445

July 8, 2010 8:54:42 AM



Page 1

Item ID: D3827-041

Accept



Revision ID:

Setup Start



Item Name: Rib Assembly (Inboard)

Stop



Start Date: 7/08/10 Start Qty: 6.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/7/18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100



Large Fab

Large Fab

Large Fab

0.00

## Memo

0.00

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c/sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch:

M109213

7- grind weld flush

8- deburr if necessary

SAN 10-07-26

CL 10-07-28

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60445

July 8, 2010 8:54:42 AM



Page 2

Item ID: D3827-041

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Start Date: 7/08/10 Start Qty: 6.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

5 10/07/08



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

5 10/07/08



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: *BK*

0.00



Packaging

Memo

0.00

Packaging

(46)

*Cpl 10-07-28*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60445

July 8, 2010 8:54:42 AM



Page 3

Item ID: D3827-041

Revision ID:

Accept



Setup Start



Item Name: Rib Assembly (Inboard)

Stop



Start Date: 7/08/10 Start Qty: 6.00



Cust Item ID:

Customer:

Required Date: 7/14/10 Req'd Qty: 6.00



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp



QC21- Final Inspection - Work Order Release

0.00

QC  
Quality Control

Memo

0.00

10/07/29 *[Signature]*

*Pl 10-7-28*  
*(6)*

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

# Picklist Print

July 8, 2010 8:54:41 AM

Work Order ID: 60445

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Page 1

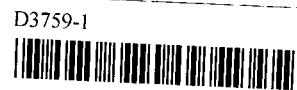


Start Date: 7/08/10  
Start Qty: 6.00

Required Date: 7/14/10  
Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	91.0000	3	18			



Location

Loc Qty

Loc Code

WA	91	
54072	9	
60190	40	
60241	42	
	100	f

M304TS0.750W.065

Purchased

No



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT	1.4628	
112398	0	
114482	1.4628	
WA	306.541185	
114520	306.541185	

115274



18  
50.52632

SAD

10-07-26

8.4210

42.1053

Pl 2810-07-28

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

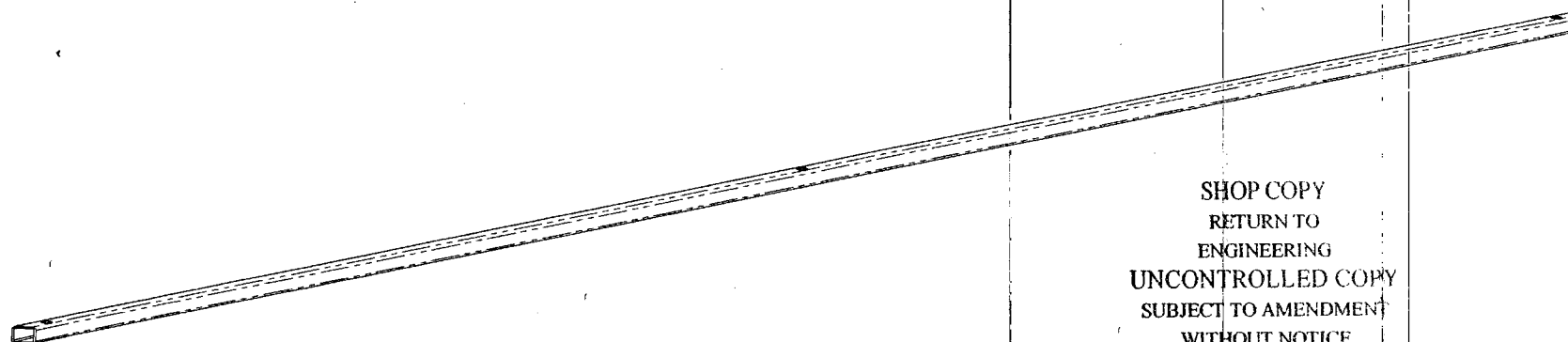
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



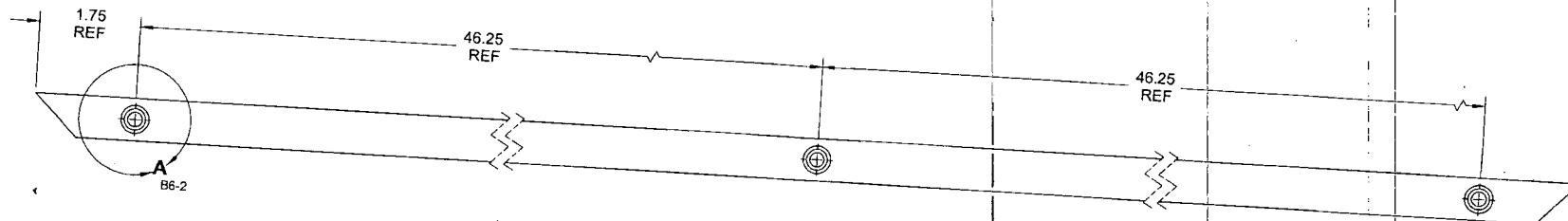
**D3827-041 RIB ASSY (INBOARD)**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60445  
CZ10/7/8

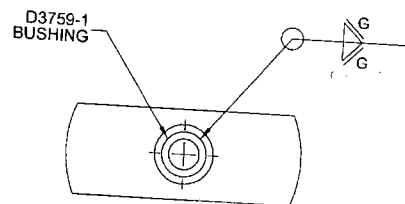
**RELEASED**  
08/11/18

NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 4.59 lbs

A	NEW ISSUE				
REV.		DESCRIPTION	MB	08.09.23	
DESIGN			BY	DATE	
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	08.09.23				
		DART AEROSPACE LTD			
		HAWKESBURY, ONTARIO, CANADA			
		DRAWING NO.			
		D3827			
		TITLE			
		RIB ASSY (INBOARD)			
		SCALE			
		NTS			
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**D3827-041 RIB ASSY (INBOARD)**

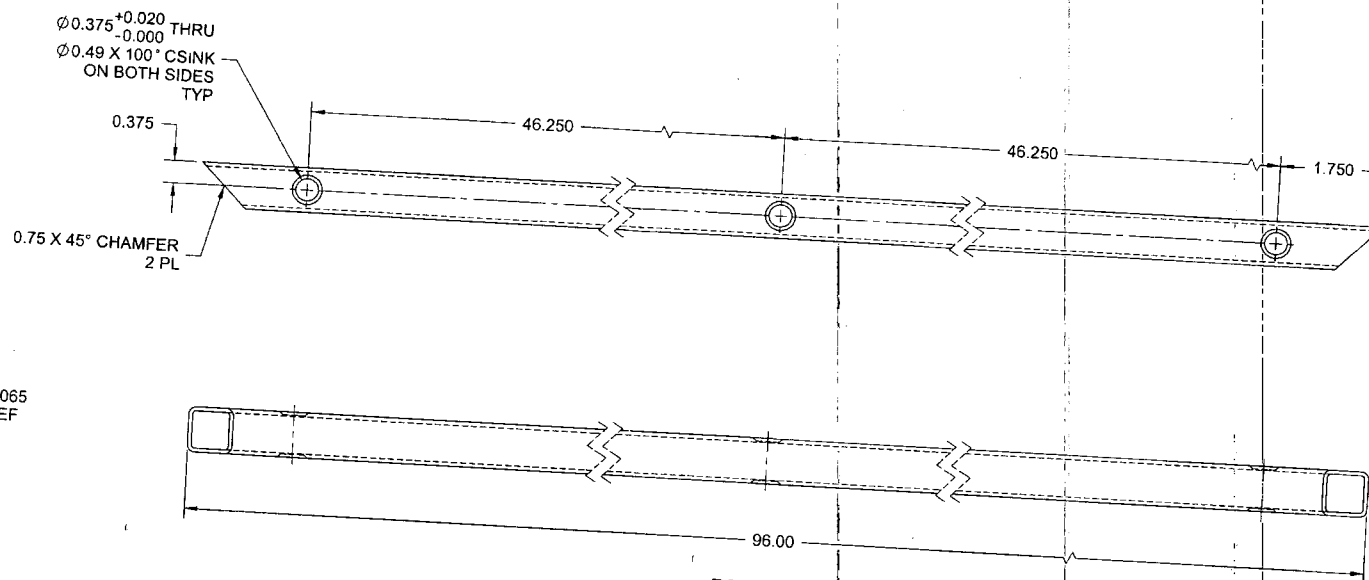


**DETAIL A** C7-2  
SCALE 2X  
3 PL

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NO. 60445

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 2 OF 3
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WORK ORDER  
NO. 60445

**RELEASED**  
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
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